

Date: Monday, 11/21/2005 11:54:47 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LABEL		
Job Number	: 24871		Part Number	: D2258220		
Estimate Number	: 10811		Drawing Number	: D2258 REV B1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/21/2005	S.O. No. : N/A	Drawing Revision	: B1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/28/2005		
Previous Run	: N/A		Qty:	10	Um:	Each
Written By	: See Comment below					
Checked & Approved By	: See Comment below					
Comment	: Est: B 04.04.15 Reformat; Clarify Step 2 KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <b>Comment:</b> PURCHASING Issue P/O: <u>144</u> Make D2258-220 read 220lb / 100kg as per Dwg D2258 Material: Red letters (1.00" min height) with adhesive back Manufacture from 3M 7mil masking film #8522CP or Avery IPM #2031 Material release note is required
2.0	D2258220	Placard  <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) WEIGHT PLACARD 220 LB
3.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment:</b> PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure material release note is attached
4.0	QC6	DIMENSIONAL CHECK  <b>Comment:</b> DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/12/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LABEL

Job Number: 24871

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 05/12/09 10

05/12/09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 18, 2005  
09:21 am

Work Order No : 0024871  
Project Name : D2258-220 Department Code:  
Project For : WK548 Burden Flags : NNNNNNN  
Work Order Type : Main WO Status : Open  
Main WO Number : Invoice State : Not Invoiced  
House Part Number : D2258-220 Invoice Date :  
Description : Placard Invoice Number :  
Manufactured : Yes Invoice Amount : 0.00  
Amount Req'd : 10  
Amount Done : 0 Order Entry No :  
Start Date : 11-18-05 OE Value : 0.00  
Est Finish Date : 11-30-05  
Act Finish Date : Est Margin : 0.000%  
Drawings Reqd : No Actual Margin : 0.000%  
Ok for Approval :  
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



## PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

### Avery Graphics™ A5 Opaque

5-year INTERMEDIATE calendered vinyl film

Dated: 10/3/02

#### Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

#### Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

#### Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)\*\*
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68° - 77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTMD 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss\*: 70 at 60°

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.<sup>2</sup> (91 cm<sup>2</sup>) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

**Typical Converting Methods:**

**CUTTING**

Computer Sign Cutting: yes

Angle of Blade: 30° or 45°

Minimum letter Height: 0.5 inch

**PRINTING**

Thermal Transfer Printing: yes

Ink Jet Printing: no

E-Stat printing: no

Screen Printing: no

**Exceptions:**

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

\*\* Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefore by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damage is caused by Avery Dennison's negligence.

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